

Date: Wednesday, 4/5/2006 3:25:39 PM
User: Kim Johnston

Process Sheet

18

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number	: 26552		
Estimate Number	: 12027		
P.O. Number	: N/A	Part Number	: D412630024
This Issue	: 4/5/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D412-630 REV. J, P13
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26136	Drawing Revision	: J
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/5/2006
Checked & Approved By	: <u>KJ 06/04/06</u>	Qty:	<u>5</u> Um: Each
Comment	: Est. Rev: B 05.08.22 Step 3 & 5 revised per ECN 700 KJ/J LM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Photocopy bluefile & create labels per PPP D412-630-024 CHG002

KJ 06-04-26 H

2.0	D2012107	Clevis
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✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

B25483

3.0	D2803042	Bracket Assembly
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✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

B26564

4.0	D2804042	Bracket Assembly
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✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

B25920

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



✓ Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Support Prop

Pick:

✓ Qty Part Number Description
2 D2807 Gas Spring

Batch

B26646

6.0

D2813

Washer



✓ Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Washer

Pick:

Qty Part Number Description
2 D2813 Washer

Batch

B26649

7.0

D33951

Bushing



† Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)
Bushing

Pick:

Qty Part Number Description
4 D3395-1 Bushing

Batch

B25935

8.0

D3388042

Step Weldment RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Step Weldment RH

Batch # B26157

9.0

AN3C21A

BOLT



X Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
BOLT

Pick:

Qty Part Number Description
2 AN3C21A Bolt

Batch

M19633

10.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Nut

Pick:

Qty Part Number Description

Batch

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 26552

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 AN310C8 Nut

M100433 M18515 20

11.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty Part Number Description
2 AN8C16 Bolt

Batch

✓ M18779 (3) M100695

12.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty Part Number Description
4 MS21043-3 Nut

Batch

M100218

13.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty Part Number Description
2 MS24665-302 Cotter Pin (or AN380C3-4)

Batch

M16941

14.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty Part Number Description
2 MS24693-C280 Screw (or MS24694-C565)

Batch

M16984

15.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty Part Number Description
6 NAS1515H3 Washer

Batch

M19633

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

NAS1515H5L

WASHER



X Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)
WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

1100050

17.0

NAS1515H8

Washer



X Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)
Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

1100446

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D412-630 p.13

341 06:06:13

(4)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06:06:13 (4)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-1	Bushing

Batch

B26565 x 7
B25921 mcp

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 26552

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~10.0000~~ Each(s)

Bushing

8

Pick: Packing Kit

Qty Part Number Description Batch

2 D2806-3 Bushing 326160

✓

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~5.0000~~ Each(s)

Strut

4

Pick: Packing Kit

Qty Part Number Description Batch

1 D2810-5 Strut 326758

✓

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~10.0000~~ Each(s)

Spacer

8

Pick: Packing Kit

Qty Part Number Description Batch

2 D3396-1 Spacer B26654 5mcy

B26645 3mcy

✓

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~5.0000~~ Each(s)

Bolt

4

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4C6A Bolt M19512

✓

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~5.0000~~ Each(s)

Bolt

4

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4C10A Bolt M18515

✓

Ⓢ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 26552

Part Number: D412630024

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	AN4C15A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10.0000~~ 8 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
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2	AN4C15A	Bolt	M100636 v
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✓

28.0	AN44C7A	Eyebolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~5.0000~~ 7 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	AN44-C7A	Eyebolt	M19620 v
---	----------	---------	----------

✓

29.0	AN5C15A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10.0000~~ 8 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
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2	AN5C15A	Bolt	M18167 v
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✓

30.0	MS210434	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~20.0000~~ 16 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
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4	MS21043-4	Nut	M100651
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✓

31.0	MS210435	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~15.0000~~ 12 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

3	MS21043-5	Nut	M18535 v
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✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 06/06/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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		01		01		01		

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Job Number: 26552

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : ~~35.0000~~ Each(s)

Washer

Pick: Packing Kit

Qty Part Number

7 NAS1515H4

Description

Washer

Batch

M100680 -

✓

33.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : ~~35.0000~~ Each(s)

Washer

Pick: Packing Kit

Qty Part Number

7 NAS1515H5

Description

Washer

Batch

M19565 -

06/06/13 ✓

06/06/12 (4)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/06/13

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-024

Location:

PPP Rev: A

06/06/14 (4)

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/15 (4)

Job Completion



06/06/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

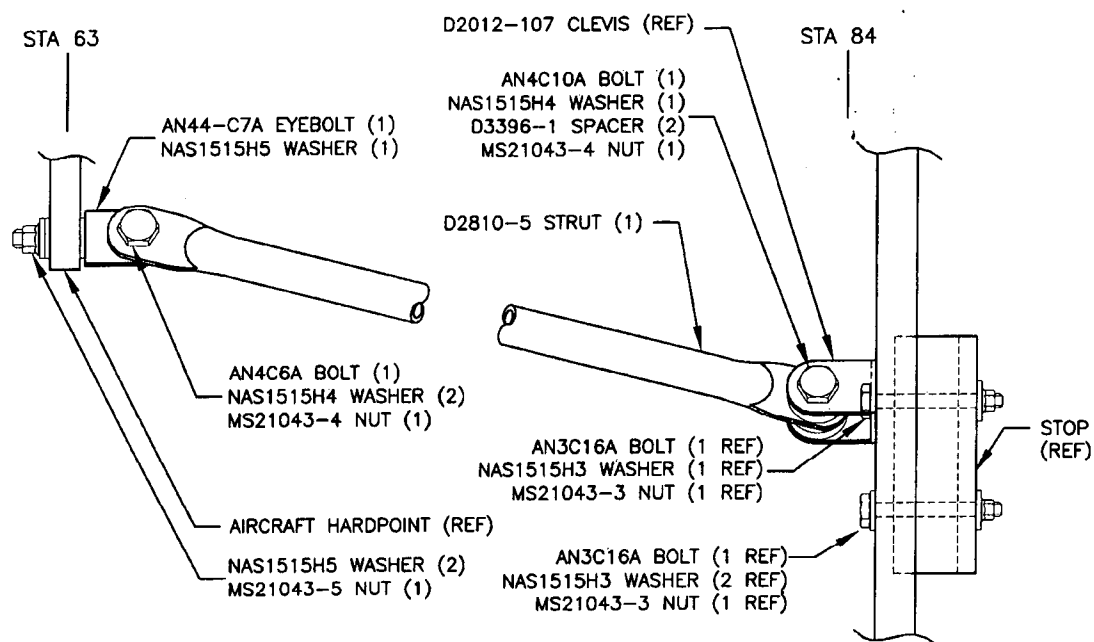
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIGURE 13 – Strut Detail for D412-630-023/-024 *Heli-Access-Step*™ Installation
(NOT TO SCALE)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26552